

Date: Wednesday, 5/16/2007 8:13:38 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-2

23

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 32379  
 Estimate Number : 10833  
 P.O. Number : N/A  
 This Issue : 5/16/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 32022  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE  
 Part Number : D29331  
 Drawing Number : D2933 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material : N/A  
 Due Date : 6/6/2007  
 Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B31386

07/07/03

mll 07/06/05

12

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

5-Deburr

07/07/04

mll 07/06/05

12

3.0 MILLING CONV CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

07/07/04

mll 07/06/05

12

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

07/07/04

mll 07/06/05

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:      Date: 07/07/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32379

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 07-07-04

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

07/07/04

12X

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

powder coating  
white per QSI 005

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

M104144

BR/M 07-07-04

12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5428

07/7/05

14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/06

11

Job Completion



7b QC3 a 070706

u 070706

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32379
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	.127	.126	.127		
B	0.100	0.140		0.127	.126	.124	.127		
C	0.100	0.140		0.120	.126	.130	.125		
D	0.210	0.230		0.224	.225	.224	.224		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	.510	.510	.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.501	2.501	2.500		
K	0.257	0.262		0.258	.258	.258	.258		
L	0.312	0.317		0.314	.314	.314	.314		
M	0.235	0.240		0.240	.240	.240	.240		
N	0.100	0.140		0.126	.126	.126	.125		
O	0.540	0.560		0.550	.551	.549	.549		
P	0.490	0.510		0.502	.496	.498	.496		
Q	3.715	3.725		3.717	3.719	3.719	3.719		
R	2.470	2.510		2.494	2.494	2.494	2.494		
S	0.240	0.270		0.252	.254	.254	.254		
T	0.100	0.180		0.137	.137	.137	.137		
U	1.625	1.635		1.631	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	.320	.320	.320		
X	1.125	1.145		1.136	1.136	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.575	1.575		
Z	0.178	0.198		0.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>ML/SA</i>
Date: 07.06.26

Audited by: <i>BE</i>
Date: 07.07.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32379
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.124	0.124	0.124		
B	0.100	0.140		0.124	0.124	0.124	0.124		
C	0.100	0.140		0.120	0.126	0.125	0.125		
D	0.210	0.230		0.224	0.223	0.224	0.224		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.240	0.239		
N	0.100	0.140		0.120	0.119	0.120	0.119		
O	0.540	0.560		0.547	0.550	0.550	0.553		
P	0.490	0.510		0.503	0.503	0.503	0.503		
Q	3.715	3.725		3.717	3.718	3.718	3.718		
R	2.470	2.510		2.492	2.492	2.493	2.496		
S	0.240	0.270		0.253	0.254	0.253	0.254		
T	0.100	0.180		0.137	0.142	0.146	0.142		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.571	1.571	1.573	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	gml
Date:	07/07/03

Audited by:	SG
Date:	07.07.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32379
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

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A	0.100	0.140		0.124	0.125	0.125	0.123		
B	0.100	0.140		0.125	0.124	0.125	0.125		
C	0.100	0.140		0.126	0.127	0.128	0.129		
D	0.210	0.230		0.223	0.223	0.224	0.224		
E	1.245	1.255		1.249	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.506	2.500	2.500	2.506		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.240	0.239	0.239		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.550	0.550	0.550	0.550		
P	0.490	0.510		0.504	0.504	0.503	0.504		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.494	2.494	2.495	2.495		
S	0.240	0.270		0.254	0.254	0.253	0.256		
T	0.100	0.180		0.142	0.141	0.143	0.143		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.367	1.367		
W	0.316	0.321		0.326	0.320	0.326	0.320		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.572	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>md</i>	Audited by: <i>SG</i>
Date: 07/07/04	Date: 07-07-04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32379
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	Page 1 of 1

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				Recorded Actual Dimensions				By	Date
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B	0.100	0.140		0.123	0.125	0.125	0.125		
C	0.100	0.140		0.128	0.129	0.125	0.128		
D	0.210	0.230		0.223	0.222	0.223	0.223		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.500	2.499	2.499	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
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M	0.235	0.240		0.239	0.238	0.238	0.239		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.551	0.550	0.550	0.549		
P	0.490	0.510		0.504	0.503	0.503	0.504		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.495	2.493	2.493	2.493		
S	0.240	0.270		0.254	0.254	0.253	0.253		
T	0.100	0.180		0.141	0.140	0.140	0.141		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.134	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.571	1.572	1.572	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>me</i>
Date:	07/07/04

Audited by:	<i>EG</i>
Date:	07/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

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